Aero Design Ltd.

Work Order Control Sheet

Work Order#: 2015-112 **Date Opened:** 26-Oct-15 **Title:** Assembly

Aircraft OEM: Bell **Aircraft Model:** 407 **Product Type:** Cargo Basket **Product Model:** High Ski **Quantity:** 1

Work Order Contents

	Initial or N/A
Work Order/Build Sheets (Procedures Provided)	JR
Additional Work Sheets (Standard Practice)	N/A
Drawings (See List Below)	JR
Parts Distribution Sheet	JR
Sub Component Tags	JR
Completed Certification	JR
Time Sheet (R&D)	N/A
Notes	N/A

Build Sheet Contents

	Initial or N/A
Tasks Initialled	JR
Dual Inspections Initialled	JR

Drawing List

Drawing #	Rev #	Description	Initial or N/A
76610	0	Basket	JR
76611	0	Body	JR
60632	0	Lid	JR
76621	0	Fwd Mount Hoop	JR
76622	0	Aft Mount Hoop	JR
76623	0	Regular Hoop	JR
76625	0	Placard	JR

Traveller

	Initial or N/A
Install walkway on lid	JR
Install lid on basket body	JR
Re-tap mounting lug holes and install mount lugs	JR
Install handle brackets	JR
Install handle	JR
Install lid prop	JR
Install data plate	JR

Component Completion

	As Instructed
Quantity Complete on This Work Order	1
Quantity Incomplete on This Work Order	N/A
Further Processing Required Before Release	N/A
Release to Stock as Components	N/A

Certification

	Initial or N/A
Form One Completed	JR
Serviceable (Green) Tag Completed	N/A
In Process (Yellow) Tag Completed	N/A
Unserviceable (Red) Tag Completed	N/A
Parts Placed in Stores for Distribution	N/A

Additional Documentation

	Initial or N/A
Documentation of a minor change	N/A
Non-Conformance Report Required	N/A
Service Difficulty Report Required	N/A

Billing

	Initial or N/A
Local (Aero Design)	JR
Research and Development	N/A
Third Party	N/A

Work performed by:	Print: J Rekve for M Rekve	Sign:	SCA: AD01	Date:	26-Oct-15
ICC / Dual Inspection preformed by:	Print: Jason Rekve	Sign:	SCA: AD01	Date:	26-Oct-15
Work Order closed by:	Print: Jason Rekve	Sign:	SCA: AD01	Date:	26-Oct-15

Aero Design Ltd.

9888 A Malaspina Rd., Powell River, BC
V8A 0G3, 604-483-AERO (2376)

Quantity: 1
PN: MS20001P4-7200
Aircraft: All Model: All
Description: Hinge
Supplier: Aircraft Spruce
Color: N/A
WO#: N/A PO# 15063

CARGO BASKET ASSEMBLY - COMMON

Complete
(initial or SCA #)

Work Order: 2015-112

Date Open: 26 Oct 15

1. Lid Assembly — A006

   a. Install lid bumpers on bottom.
      i. Fill bumper holes with RTV silicone sealant.
      ii. Insert 49205-14 lid bumper, 3 or 4 places per lid.

   b. Install placard on bracket on top of lid.
      i. Locate placard on bracket.
      ii. Drill #30 through placard and bracket, using holes in placard.
      iii. Remove placard and de-burr holes in placard and on bracket.
      iv. Locate placard on bracket, and cleco in place.
      v. Rivet placard with four CR3213-4-02 CherryMax rivets.

   c. Option: Install walkway on top of lid (lid must be fitted with walkway provisions)
      i. Note: avoid touching surface of tread plate with bare hands to prevent smudges or marks on the top surface.
      ii. Pull tread plate from stock. Shear tread plate to length.
      iii. De-burr edges of tread plate with scotch-brite disc on die-grinder.
      iv. Locate tread plate on lid. Hold tread plate in place with bags of lead shot.
      v. Mark and drill #30 holes:
         1. 0.25" from edge of tread plate, centre on cross members (0.38")
         2. 0.25" from edge of tread plate, middle of each walkway stringer
      vi. De-burr and counter-bore (if required to provide clearance of rivet head on checker pattern) all holes in tread plate using ¼" piloted counter bore on both sides.
      vii. De-burr holes in lid tubes.
      viii. Apply bead of RTV silicone sealant along all tubes under tread plate.
      ix. Set tread plate in place, secure with clecos if necessary.
      x. Rivet placard with CR3213-4-02 CherryMax rivets

   d. Record PO/WO of all parts (including lid) used in steps above on attached material tracking list.

2. Body Assembly — A006

   a. Install attachment fittings
      i. Carefully remove excess powder coat from around attachment lug threads using a countersink.
      ii. Run 3/8-24 tap into attachment lugs to clear threads.
      iii. Apply anti-seize compound to attachment fittings 96710-01 (alternate: Ancra 40088-14)
      iv. Install attachment fittings with two NAS1149F0363P washers in four lugs in basket.
         1. 90610 (Robinson R44) basket only:
            a. Install 1 fitting 906?? in lower forward attachment lug only.
            b. Install 3 96710-01 fittings in remaining locations.
      v. Torque to ??

b. 946 Basket Only: Install Cutout Brace – *must be completed after hinge installation*
   i. Locate 94621-01 Brace over aft cross tube cutout
   ii. Install two AN4-6A bolts and two AN4-30A bolts with NAS1149F0463P washers.
   iii. Torque AN4 bolts to ??

c. Record PO/WO of all parts (including basket) used in steps above on attached material tracking list.

3. Hinge Installation AOC6
   a. Prepare hinge.
      i. Cut hinge to length:
         1. 776, 906 – 54"
         2. 751, 803 – 70"
         3. 698, 764, 945 – 72"
         4. 784 – 90"
         5. 940, 946, 959 – 95"
      ii. Drill #30 pilot holes using hinge jig. For long hinges, flip at specified location on jig.

   b. Install hinge on basket
      i. Locate hinge on basket (standard baskets)
         1. centre fore/aft
         2. 0.15" – 0.18" up from bottom edge
      ii. Locate hinge on basket (extra wide baskets)
         1. centre fore/aft
         2. set hinge at 90 degrees (as if lid would be installed) using a small square, locate vertical side at 22.5" from outboard edge.
      iii. Drill #30 through holes in hinge into basket rim. Cleco in place with 1/8 (copper) clecos.
      iv. Drill holes up to #21 through hinge and rim. Replace 1/8 clecos with 5/32 (black) clecos.
      v. Remove hinge and de-burr holes in hinge and basket rim.
      vi. Cleco hinge to basket with 5/32 clecos.
      vii. Install hinge with CherryMax rivets
         1. CR3523-5-02 monel rivets – last 2 rivets in each end
         2. CR3213-5-02 aluminum rivets – all other locations

   c. Install lid on basket
      i. Locate lid on hinge (all baskets)
         1. center fore/aft
         2. 0.15" – 0.18" down from top edge
      ii. Drill #30 through holes in hinge into lid rim. Cleco in place with 1/8 clecos.
      iii. Drill holes up to #21 through hinge and rim. Replace 1/8 clecos with 5/32 clecos.
      iv. Remove hinge and de-burr holes in hinge and lid rim.
      v. Cleco lid to hinge with 5/32 clecos.
      vi. Install hinge with CherryMax rivets
         1. CR3523-5-02 monel rivets – last 2 rivets in each end
         2. CR3213-5-02 aluminum rivets – all other locations

d. Record PO of hinge and rivets on attached material tracking list.

4. Install Handle AD04

a. Install handle brackets.
   i. Set 84267-01 handle bracket on provisions in hoops, 2 places.
   ii. Install AN3-11A bolt, NAS1149F0363P washer (2), MS21044N3 nut. Two places per bracket, two brackets per basket.
   iii. Torque AN3 bolts to ??.

b. Install handle
   i. Trim 36278-01R and 36278-01L springs to ensure end of spring does not extend past edge of handle bracket, approximately 1/8". Set springs over bushing of 84261-01 handle assembly.
   ii. Grease two 36275-01 bushings with ??. Insert into bushings of handle assembly.
   iii. Locate handle on basket lid. Insert AN3-12A bolt with NAS1149F0363P through bracket on lid and handle bushing on one end of handle.
   iv. On other end of handle, hook spring over catch rivet on handle assembly and use spring tool to twist spring to catch arm on bracket on lid while inserting AN3-12A bolt with NAS1149F0363P washer through lid bracket and handle bushing.
   v. At first end, remove bolt and repeat step iv.
   vi. Install NAS1149F0363P washer and MS21044N3 nut on both AN3-12A bolts.
   vii. Torque AN3 bolts to ??.

c. Check handle
   i. Operate handle to ensure handle does not bind and springs hold handle in.
   ii. Snap handle into brackets to ensure handle locks.

d. Record PO/WO of all parts used in steps above on attached material tracking list.

5. Install lid brace AD06

a. Locate 36280-01 lid brace on bushing in basket. Ensure brace is on forward end of basket as it will be installed on the helicopter.
b. On lid end, insert AN970-3 washer into end of lid brace. Insert AN3-15A bolt with NAS1149F0363P washer through AN970-3 washer, lid prop, and lid bushing. Install NAS1149F0363P washer and MS21044N3 nut on bolt.
c. On basket end, insert AN3-17A bolt with AN970-3 washer through lid prop and basket bushing. Install NAS1149F0363P washer and MS2144N3 nut on bolt.
d. Ensure brace is seated on lip of bushings before tightening nuts.
e. Torque AN3 bolts to ??
f. Record PO/WO of all parts used in steps above on attached material tracking list.

6. Final Inspection

   Dual inspection by a different person than assembled the basket.

   a. Check for general condition and correct assembly:
      i. Bolts are tight
      ii. Rivets are installed correctly
      iii. Handle operates correctly
      iv. Lid brace operates correctly
   b. Check that PO/WO numbers have been recorded.

CARGO BASKET HANDLE FABRICATION

General

These instructions apply to all cargo basket handle assemblies. Refer to the following drawings, at the current revision, for dimensions and details:

All Models: 84261, Rev. 1

Work Order: 2015-112

Date Open: 20 Oct 15

Complete (initial or SCA #)

1. Weld Lever Assembly – handle lever jig required — AD-05
   a. Set MS20615-4M3 monel rivet into socket in jig
   b. Set 36274-01 bushing into socket in jig
   c. Set 84261-01 lever onto handle jig, with rivet and bushing protruding into lever.
   d. TIG weld around bushing using ER308L rod.
   e. Fuse weld rivet to lever. Additional ER308L rod may be used if required.
   f. Repeat steps a-f using hole/socket on opposite side of jig to make opposite lever assembly.
   g. Record material POs on attached material list.

2. Clean up
   a. Clean lever assembly by media blasting with glass bead.
   b. Drill out lever bushing to O (0.316) on lathe:
      i. Grasp bushing in chuck, ensure rivet clears between the jaws.
      ii. Run at 300 RPM.
      iii. Apply a drop of Rapid-Tap to drill.
   c. De-burr.

3. Fabricate Handle Assembly — AD06
   a. Temporarily install handle levers (from step 2) on lid assembly. Ensure long side of handle bushings are on INSIDE (pointing together).
   b. Measure across TOP side of levers.
   c. Cut handle tubing to length measured.
      i. Handles under 40" long: 1.0" x 0.035 round tube
      ii. Handles over 40" long: 1.0" x 0.065 round tube
   d. De-burr tube.
   e. Insert tube into handle levers. Tap with a plastic mallet to seat tube flush with lever. Raise handle to ensure both levers touch stops to check alignment.
   f. Record material PO on attached material list.

4. Weld Handle Assembly — AD-05
   a. Fuse tube to lever on both ends. Ensure levers are parallel.

5. Clean up — AD06
   a. Clean welded area with scotch-brite.

6. Final Inspection – OK
   To be completed by a different person than the previous steps.
   a. Welds for complete and handle for fit.
   b. Tag complete and inspected parts in preparation for installation.

Aero Design Ltd.
9888 A Malaspina Rd., Powell River, BC
V8A 0G3, 604-483-AERO (2376)

Quantity: 1
PN: Aluminum Checker plate
Aircraft: All Model: All
Description: 5 7/8" x 10', .065", pattern c102
Supplier: Daigle Marine
Color: N/A
WO#: N/A PO# 15056

Aero Design

Parts Distribution Sheet

Description: Handle Bar Installation Kit WO#

From PO or WO #	Quantity	Description	Part Number	For WO #
15006	4	Stud Fitting	96710-01	
14048	8	Washer	NAS1149FO663P	
14068	4	Bolt	AN3-11A	
Several	2	Bolt	AN3-12A	
13050	2	Brass Bushing	36275-01	
15031	12	Washer	NAS1149FO363P	
14072	6	Nut	MS21044N3	
13085	1(LH)	Spring	36278-01	
13085	1(RH)	Spring	36278-01	
15025	4	Bumper	M1417705	
15031	15	WASHER	NAS1149FO363P	
2015-90	1	LID BRACE	84280-01	
15063 / 14091	1	Hinge	MS20001PH-7200	
15073	1	TUBE (handle)		
2015-42	2	Lever Assembly	84261-02	
2015-02	2	handle bracket	84267-01	
14084	1	BOLT	AN315A	
15031	1	BOLT	AN3-17A	
15014	2	WASHER	AN970-3	

407 HIG4

Aero Design

Parts Distribution Sheet

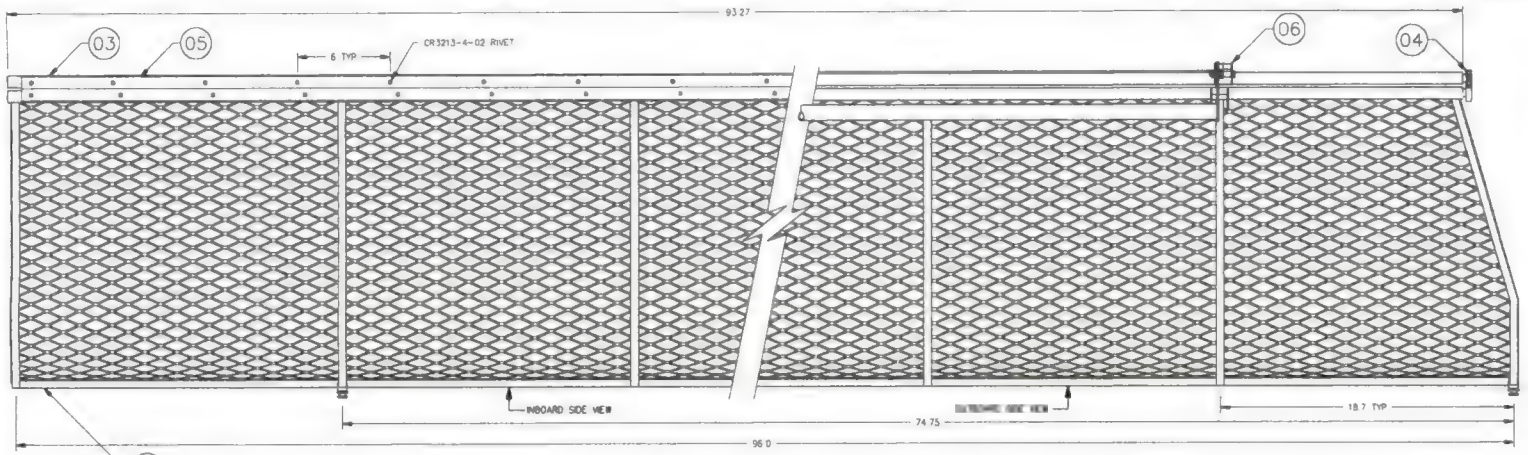
Description: Beam Pin

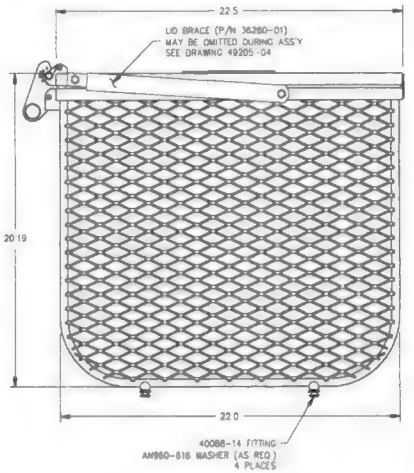
WO# N/A

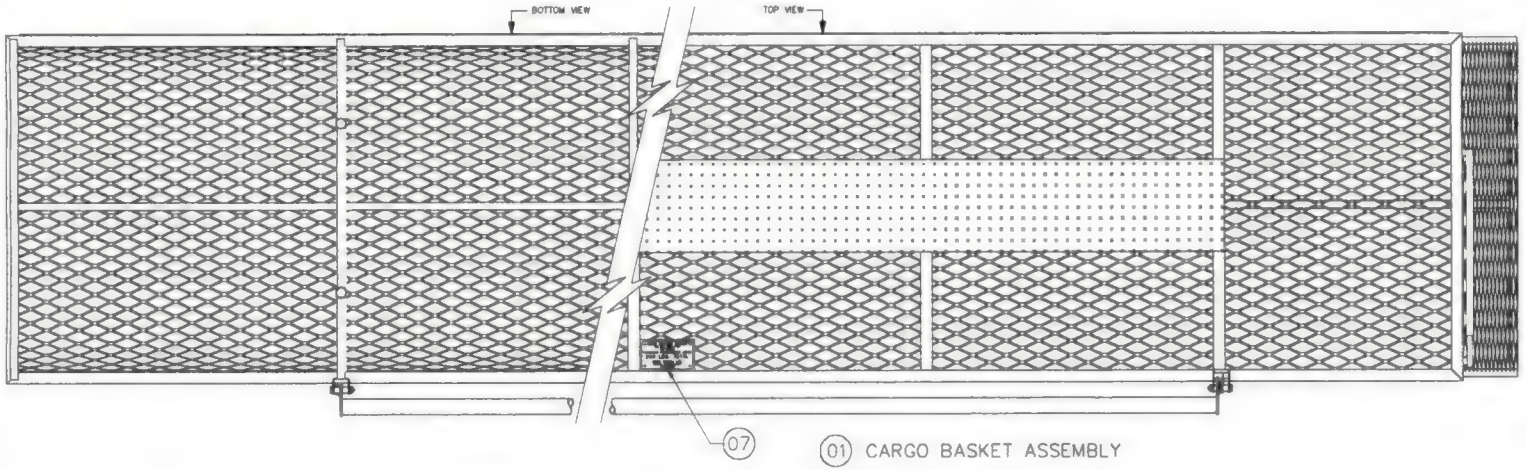
From PO or WO #	Quantity	Description	Part Number	For WO #
2014-91	1	Stop	69830-21	
13032	1	Spring	N/A	
13027	1	Screw	MSFP011300	
2012-25	1	Knob	69830-22	
10049	1	Nut	MS21044C3	
13027	1	Screw	MSFP011300	
12001	1	nut	MS21044C3	
12094	1	washer	AN960C10	
	1	stop	76630-14	

2015-112

REV	DESCRIPTION OF CHANGE	INITIALS	DATE
0	CREATED FROM 80630	BJC	SEPT 25/07

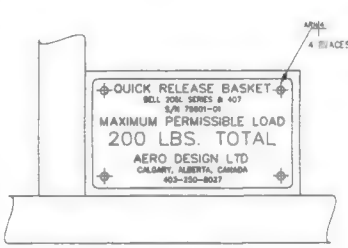




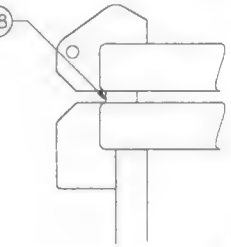


(01) CARGO BASKET ASSEMBLY

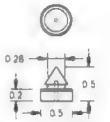
NOTE
1. ALL DIMENSIONS SHOWN ARE FOR REFERENCE ONLY. DIMENSIONS OF COMPONENTS AND COMPLETE ASSEMBLY ARE DETERMINED IN PREVIOUS STEPS.



DETAIL B
SCALE 1 : 1
LOOKING AT PLACARD BRACKET



BUMPER INSTALLATION
SCALE 1 : 1



(08) BUMPER
SCALE 1 : 1

QTY	PART NO	ITEM	DESCRIPTION	MATERIAL
A/R	CR3213-4-02		CHERRY RIVET	
A/R	AN960-616		WASHER	
4	40088-14		FITTING	ANCRA
A/R	49205-14	08	BUMPER	ARGUS INDUSTRIES
1	76625-01	07	PLACARD	
1	36255-01	06	HANDLE BAR INSTALLATION	
1	MS20001P4	05	PIANO HINGE	
1	36256-01	04	BRACE INSTALLATION	
1	80632-01	03	LID ASSEMBLY	
1	76611-01	02	BASKET BODY ASSEMBLY	
	76610-01	01	CARGO BASKET ASSEMBLY	

LIST OF MATERIALS

APPROVALS		DATE
DRAWN	JEFF CLARKE	25 SEPT 2007
CHECKED	E. BURGOIN	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES.
TOLERANCES ON:
DECIMALS: X.XXX ±0.010; X.XX ±0.03; X.X ±0.1
ANGLES: ±1/2°

AERO DESIGN LTD.
CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAR 290M
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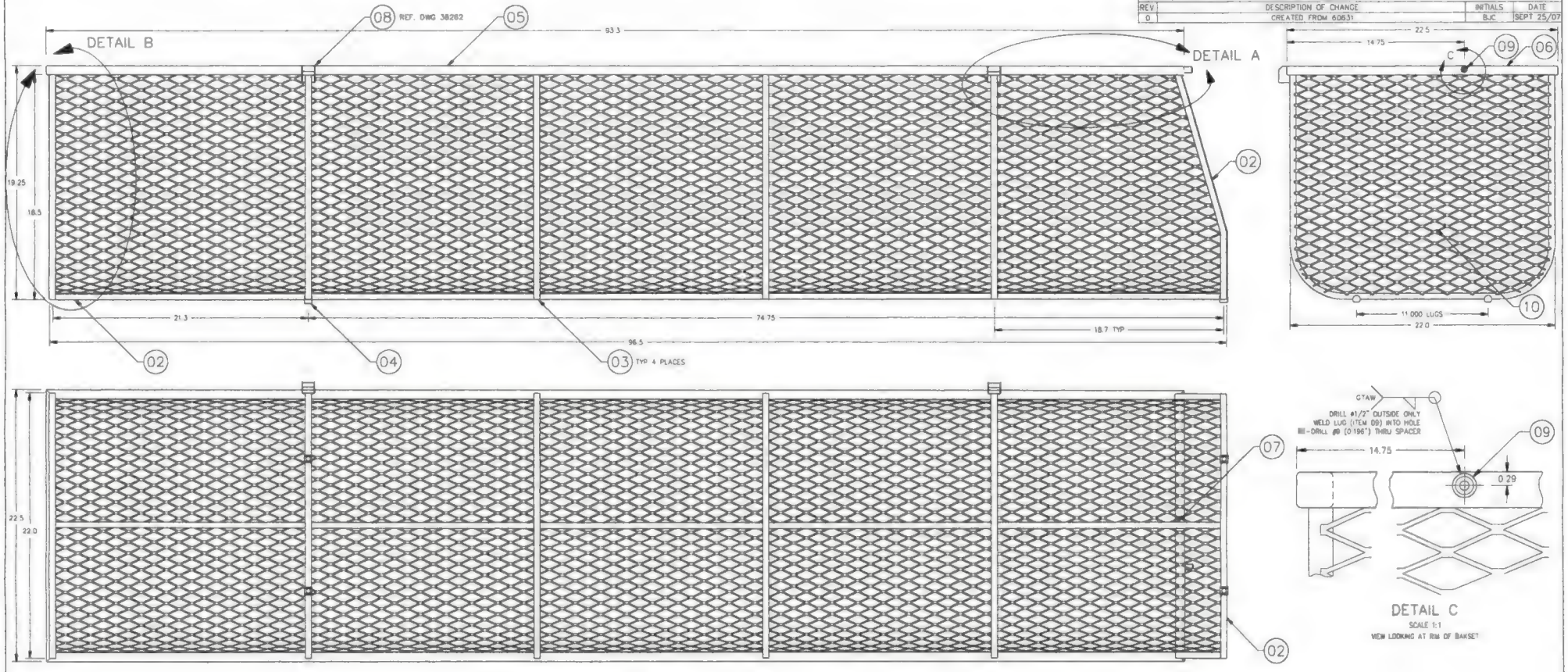
tel: (403) 250-8037 fax: (403) 250-8088 aerodesign@telusplanet.net

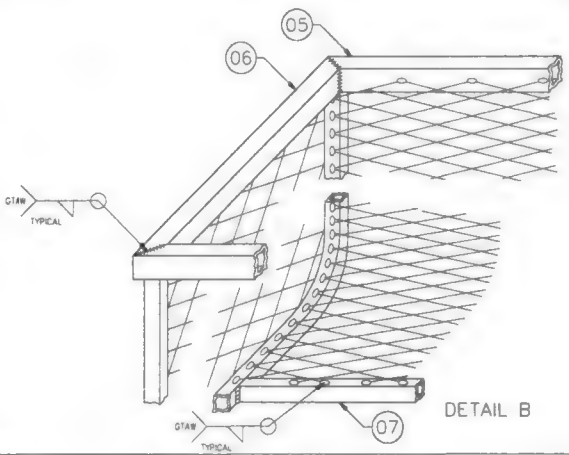
BELL 407, 206L SERIES
QUICK RELEASE HIGH MOUNTED CARGO BASKET
CARGO BASKET ASSEMBLY

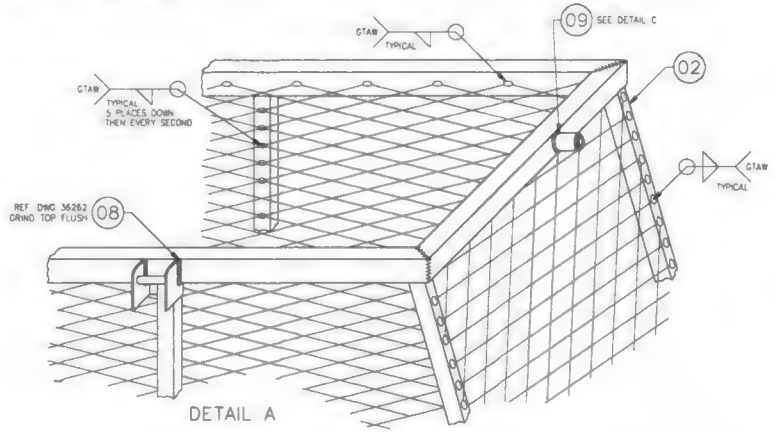
SCALE 1 : 4	DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 1	A1	76610	0

REV	DESCRIPTION OF CHANGE	INITIALS	DATE
0	CREATED FROM 60631	BJC	SEPT 25/07



01 BASKET BODY ASSEMBLY





NOTES
1. REMOVE ALL BURRS AND BREAK SHARP EDGES
2. WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AMS 2685C
   WELDING ROD SHALL CONFORM TO ER70S-2 OR EQUIVALENT
3. WHEN ASSEMBLY IS COMPLETE, FILL ALL VENT HOLES WITH ROSETTE WELD
4. THOROUGHLY CLEAN AND POWDER COAT BASKET SUB-ASSEMBLIES PRIOR TO ASSEMBLY

A/R	3/4-16F	10	MESH		16 GAUGE
1	49215-01	09	LUG		
1	36262-01	08	HANDLE BRACKET ASS'Y		
5	60643-01	07	SPINE		
2	49212-01	06	RIM		
2	60640-01	05	RIM		
1	76622-01	04	ATTACHMENT HOOP		
4	76623-01	03	HOOP		
1	76621-01	02	END HOOP ASS'Y		
	76611-01	01	BASKET BODY ASSEMBLY		
01	PART NO	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC
QTY.			LIST OF MATERIALS		

APPROVALS		DATE
DRAWN	JEFF CLARKE	25 SEPT 2007
CHECKED	E. BURGOIN	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES ON
DECIMALS: X.XXX ±0.010; X.XX ±0.03; X.X ±0.1
ANGLES: ±1/2°

AERO DESIGN LTD.
CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAR 290M
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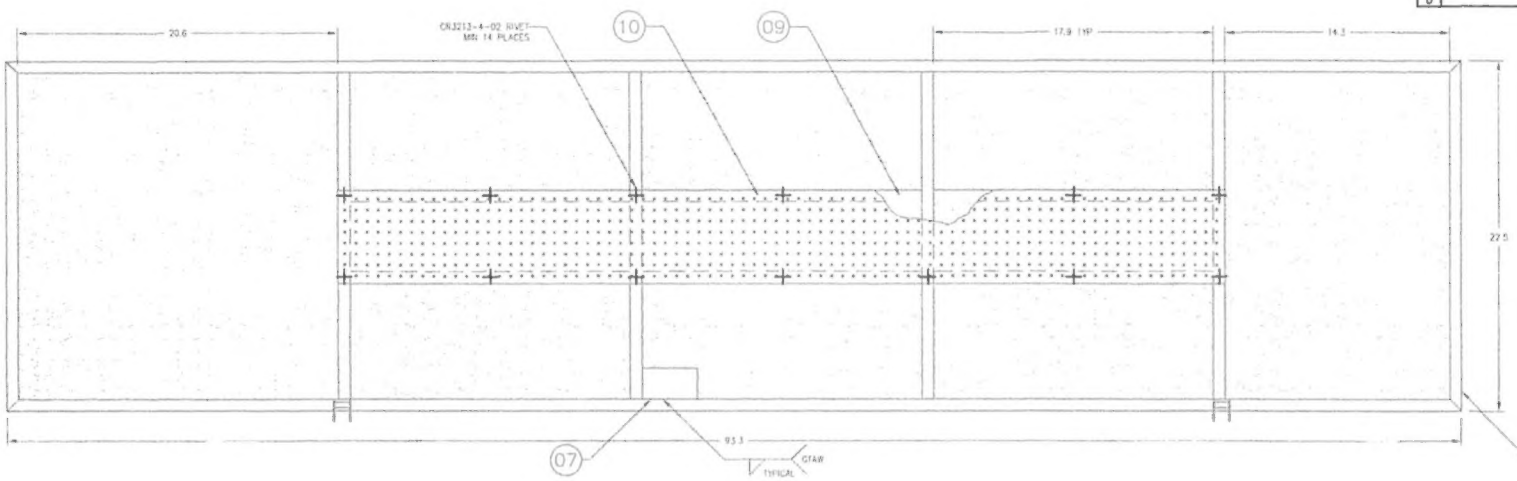
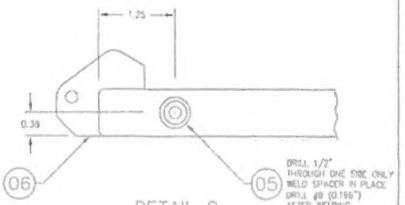
tel: (403) 250-8007 fax: (403) 250-8085 aerodesign@telusplanet.net

BELL 407, 206L SERIES
QUICK RELEASE HIGH MOUNTED CARGO BASKET
CARGO BASKET BODY ASSEMBLY

SCALE 1 : 4	DWG. SIZE	DWG. NO.	REV
SHEET 1 OF 1	A1	76611	0

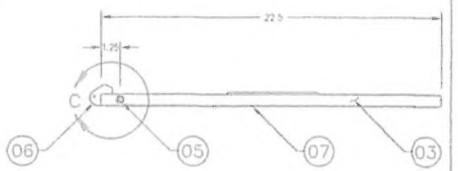
REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		



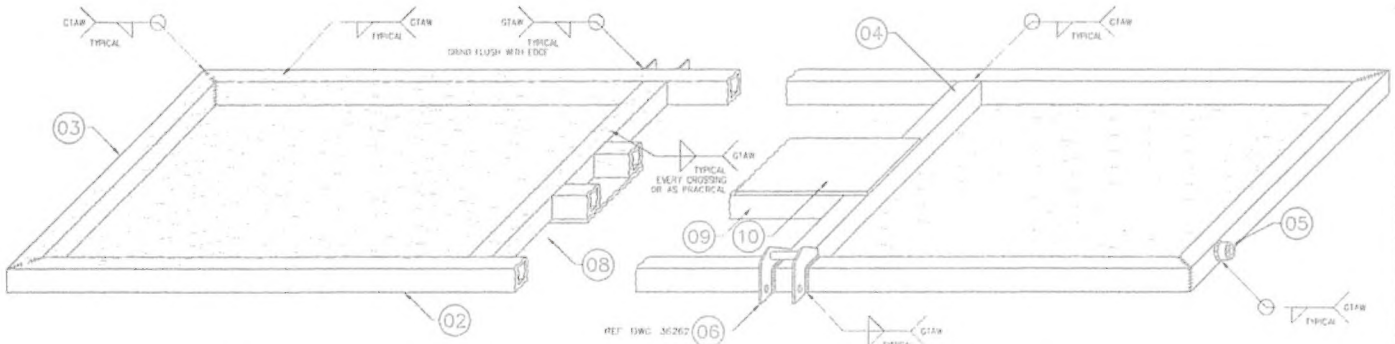


DETAIL C
SCALE 1 : 1

01 BASKET LID ASSEMBLY



NOTES
1. REMOVE ALL BURRS AND BREAK SHARP EDGES
2. WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AMS 2680C
   WELDING ROD SHALL CONFORM TO ER70S-2 OR EQUIVALENT.
3. WHEN ASSEMBLY IS COMPLETE, FILL ALL VENT HOLES WITH ROSETTE WELD.
4. THOROUGHLY CLEAN AND POWDER COAT BASKET SUB-ASSEMBLIES PRIOR TO ASSEMBLY



DETAIL B
LOOKING AT BOTTOM

DETAIL A
LOOKING AT TOP

A/R	60632-10	10	TREAD PLATE	ALUMINUM	COMMERCIAL
6	60649-01	09	STEP BRACE		
A/R	3/4-16F	08	MESH	4' x 8' SHEET	18 GAUGE
1	36204-10	07	PLACARD BRACKET		
1	36262-01	06	UPPER HANDLE BRACKET ASS'Y		
1	49216-01	05	LUG		
4	49213-01	04	LID BRACE		
2	49212-01	03	RIM		
2	60640-01	02	RIM		
	60632-01	01	BASKET LID ASSEMBLY		
01	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC.
QTY.	LIST OF MATERIALS				

APPROVALS		DATE
DRAWN:	JEFF CLARKE	12 AUG 2004
CHECKED:	E. BURGOIN	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES.
TOLERANCES ON:

DECIMALS		ANGLES
X.XXX	±0.010	±1/2°
X.XX	±0.03	
X.X	±0.1	

AERO DESIGN LTD.
CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAR 2808
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tel: (403) 250-8027 fax: (403) 250-8933 aerodesign@telusplanet.net

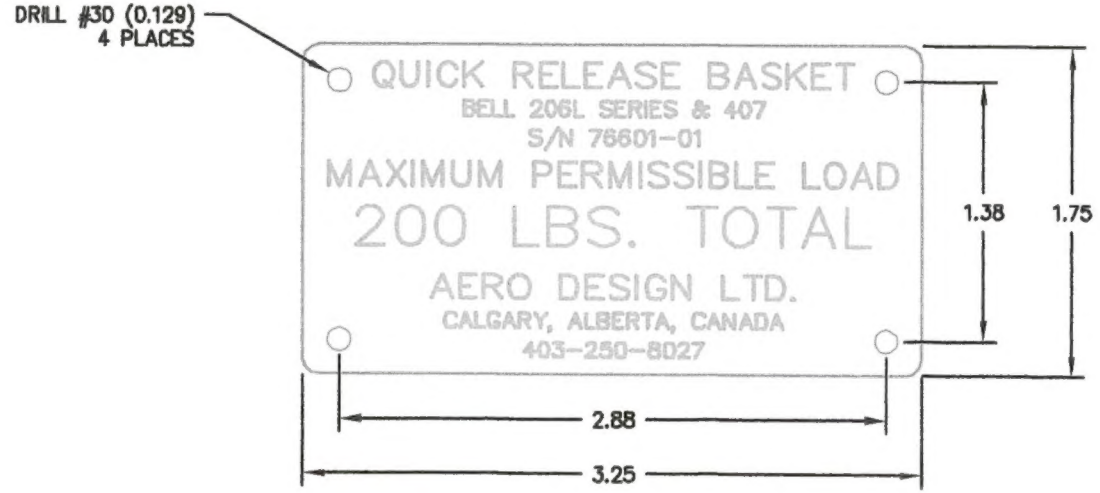
BELL 407, 206L SERIES
HIGH SIDE MOUNTED CARGO BASKET
CARGO BASKET LID ASSEMBLY

SCALE 1 : 4	DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 1	A1	60632	0

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
1			

NOTES

1. ENGRAVE 0.007 DEEP AS FOLLOWS:
   "QUICK RELEASE BASKET" – 0.125 HIGH
   "BELL 206L SERIES & 407" – 0.080 HIGH
   "S/N 76601–XX" – 0.080 HIGH
   "MAXIMUM PERMISSIBLE LOAD" – 0.125 HIGH
   "200 LBS. TOTAL" – 0.200 HIGH
   "AERO DESIGN LTD." – 0.125 HIGH
   "CALGARY, ALBERTA, CANADA" – 0.080 HIGH
   "403–250–8027" – 0.080 HIGH



01 PLACARD

1	76625–01	01	PLACARD	6061–T6 ALUMINUM	QQ–A–250/11	0.063 SHEET
01	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
QTY	LIST OF MATERIALS					

APPROVALS		DATE
DRAWN:	JEFF CLARKE	26 SEPT 2007
CHECKED:	E. BURGOIN	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES.
TOLERANCES ON:

DECIMALS		ANGLES
X.XXX	±0.010	±1/2°
X.XX	±0.03	
X.X	±0.1	

AERO DESIGN LTD.
CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAR 290M
2013 – 39TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2E 6R7
tel: (403) 250–8027 fax: (403) 250–8333 aerodesign@telusplanet.net

BELL 206L SERIES AND 407
QUICK RELEASE HIGH MOUNTED CARGO BASKET
PLACARD

SCALE 1 : 1	DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 1	A1	76625	0

Aero Design Ltd.

9888 A Malaspina Rd., Powell River, BC
V8A 0G3, 604-483-AERO (2376)

Quantity: N/A
PN: N/A
Aircraft: All Model: All
Description: Spring
Supplier: N/A
Color: N/A
WO#: N/A PO# 13032

1. Approving Civil Aviation Authority/Country	2. AUTHORIZED RELEASE CERTIFICATE FORM ONE	3.Form Tracking No.
Transport Canada		

4. Organization Name and Address	5. Work Order/Contract/Invoice
AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3	WO 2015-112

6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work
	Cargo Basket Ass'y	76610-01	1	76601-19	New

12. Remarks

Modified with walkway on lid IAW DCL704

13a. Certifies that the items identified above were manufactured in conformity to:

☒ Approved design data and are in condition for safe operation.

☐ Non approved design data specified in block 12.

14a. ☐ CAR 571.10 Maintenance Release

☐ Other regulation specified in block 12

Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the *Canadian Aviation Regulations*.

13b. Signature	13c. Approved Organization Number	14b. Signature	14c. Approved Organization Number
JC AD02	AMF 73-04		
13d. Name	**13e. Date (dd/mmm/yyyy)**	**14d. Name**	**14e. Date (dd/mmm/yyyy)**
Jeff Clarke - AD02	02 Nov 2015		

Alpine

Installer Responsibilities

This certificate does not constitute authority to install.

Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.

Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.